

Work Order ID 61710

Tuesday, August 31, 2010 1:53:29 PM

Page 1



Item ID: D3793-1

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 8/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:



Date: 08-31-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3793	Rev A	

100



FLOW WATER JET

Waterjet

Memo

0.00

B10-9-8

FLOW CNC Waterjet

304 .40

1-Cut as per Dwg D3793

 Dwg Rev: A Prog Rev: A 2-

Deburr if necessary

(13)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

B10-9-9

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

S1010109

(13)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61710

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Item ID: D3793-1

Accept



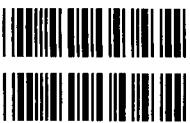
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Stop



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Start Qty: 10.00



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Required Date: 9/7/2010

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

(13)

Brake NC

Memo

0.00

Brake NC

1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs 3-Form Joggle on brake using Jig as per Dwg D3793

SD 10/09/09

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

SD 10/09/09

(43)

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Bk 10-9-10

Powdercoat

Memo

0.00

Powder Coating

START TIME:

10:20

OVEN TEMPERATURE:

220

FINISH TIME:

10:50

(13)

W/O:		WORK ORDER CHANGES					
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Work Order ID 61710

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Item ID: D3793-1

Accept



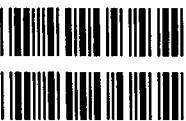
Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 8/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

M 10/09/13

X13

QC

Quality Control

170



Identify as per dwg & Stock Location:

FP-18

0.00

BK 10-9-13

(13)

Packaging

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

10/09/14

X9

10/09/14

QC

Quality Control

Memo

0.00

B810-9-13
(13)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, August 31, 2010 1:53:34 PM

Page 1

Work Order ID: 61710



Parent Item: D3793-1



Parent Item Name: Wearshoe

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	111.7987	0.5902	6.212632	7.7	 HB 10-9-8	

304/316 .040 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	16.1522	
114574	16.1522	
MAT20	95.6465	
112885	2.7475	
113062	0.699	
115440	92.2	115440

(13)

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DART AEROSPACE LTD	Work Order:	61710
Description: Wearshoe	Part Number:	D3793-1
Inspection Dwg: D3793	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>JK</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-9-8	Date:	10/09/69	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	 

W/O:		WORK ORDER CHANGES					
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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

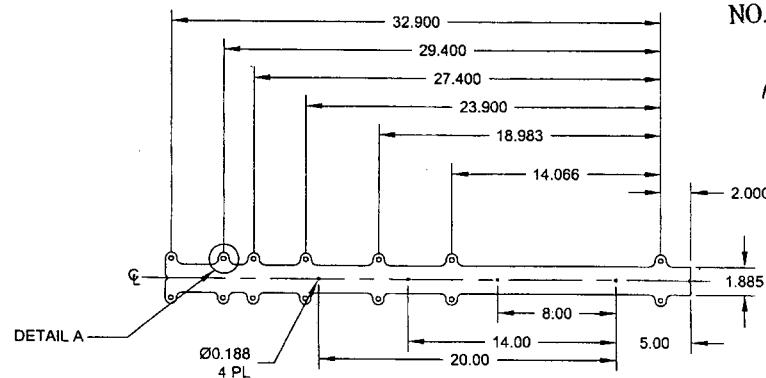
SUBJECT TO AMENDMENT

WITHOUT NOTICE

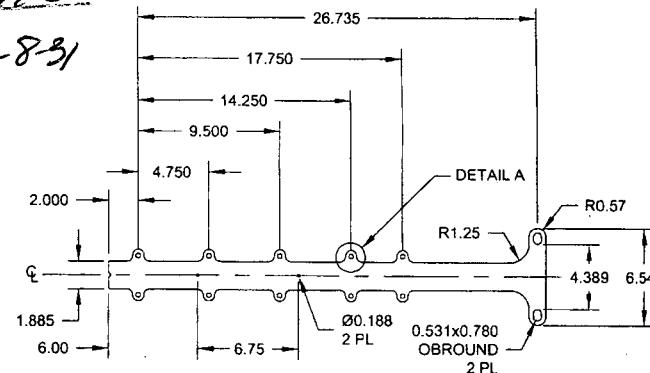
WORK ORDER

NO. 6170

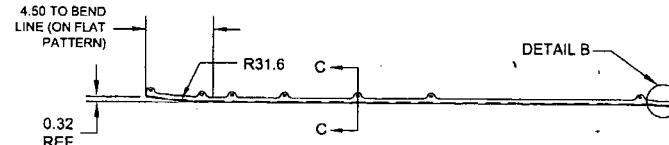
B710-831



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14	SCALE	NTS

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3793 REV. A
SHEET 1 OF 2

TITLE WEARSHOE

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*RELEASED
08.05.23.14*

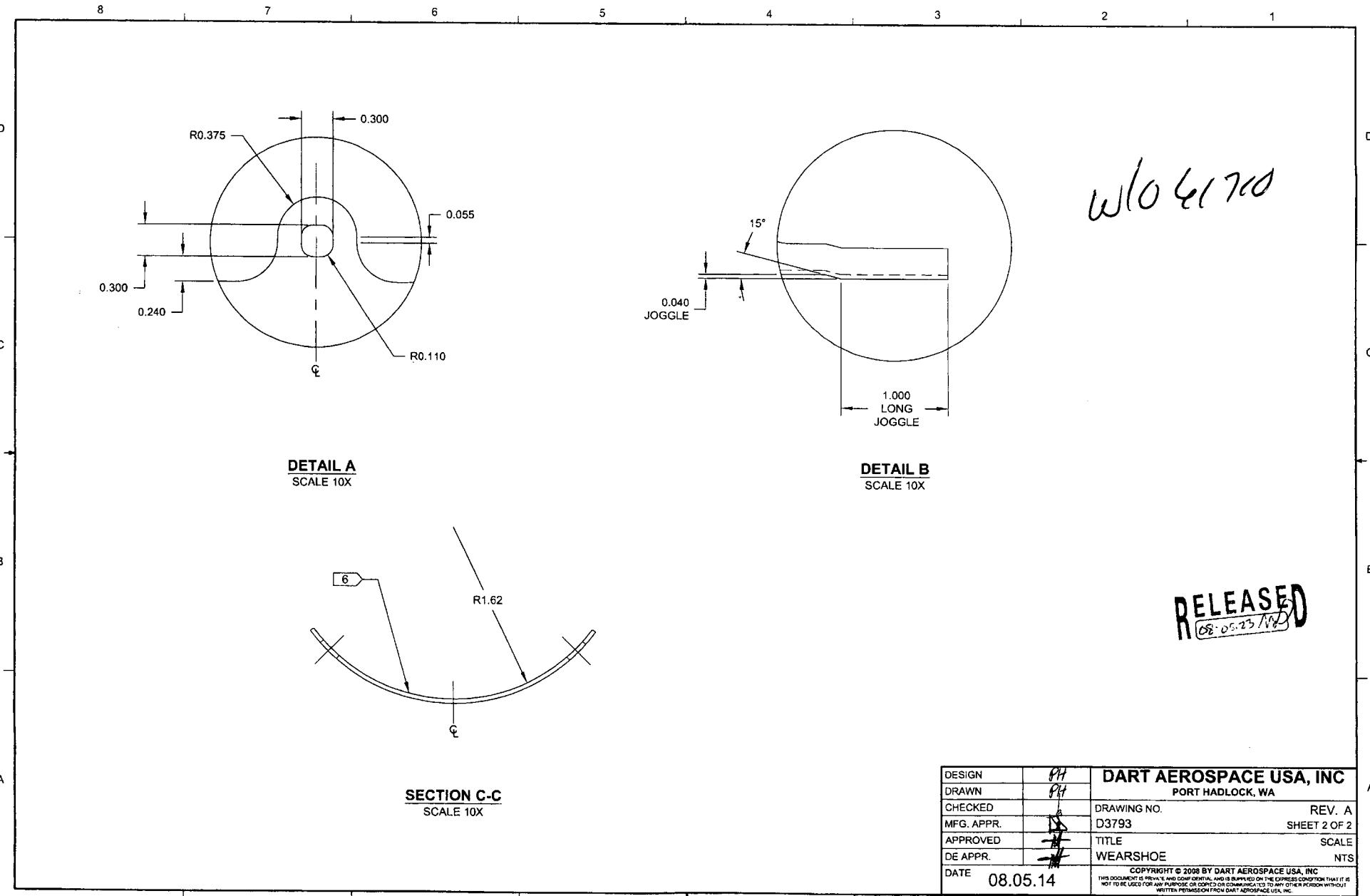
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